

Date: Monday, 18/08/2008 3:46:15 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | LONG T-HANDLE ASSEMBLY |
| Job Number : | 41381 | | |
| Estimate Number : | 13522 | | |
| P.O. Number : | | Part Number : | PB674300151 |
| This Issue : | 18/08/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | B6743001 P.13 |
| First Issue : | // | Project Number : | N/A |
| Previous Run : | 40770 | Drawing Revision : | B1 |
| | Type : | Material : | |
| | SMALL /MED FAB | Due Date : | 18/09/2008 |
| Written By : | | Qty: | 5 Um: Each |
| Checked & Approved By : | JLD 08.8.18 | | |
| Comment : | Est Rev:A 08-07-25 new issue DD verified by:ec | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------------|----------|
| 1.0 | PB674300187 | Tube Arm |
|-----|-------------|----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tube Arm

batch: 341215 ✓

*

W/O

attached Pl 08.09.30

| | | |
|-----|-------------|-------------|
| 2.0 | PB674300191 | Tube Handle |
|-----|-------------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tube Handle

batch: 341216 ✓

*

W/O

attached Pl 08.09.30

| | | |
|-----|-------------|--------------|
| 3.0 | PB674300193 | Tube End Cap |
|-----|-------------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Tube End Cap

batch: 340074 ✓

*

St = deburr Silvio

Pl 08.09.30

| | | |
|-----|-------------|------------------------------|
| 4.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1- drill #40 hole in center of -91 before welding -93 caps, to let air out

2- weld -93 to -91 as per dwg

3- grind weld flush

4- assemble -87 under the pilot hole in -91 and weld as per dwg

Pl 08.09.30

(X5)

| | | |
|-----|-----|------------------------------|
| 5.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

E 08/09/30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG T-HANDLE ASSEMBLY

Job Number: 41381

Part Number: PB674300151

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-30 (5)

7.0

PB674300189

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Clevis

batch: 40093

SL 08-10-01 5

8.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

SPRING SLOTTED PIN

batch: 17850

SL 08-10-01 5

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- line drill -89 and -87 using existing pilot hole of -87 as per dwg
2- install spring pin

SL 08-10-01 5

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0810-01 (5)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 4:00

OVEN TEMPERATURE: 320°F

FINISH TIME: 4:30

M 102316

(54)

M-L 08/10/03

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/10/03 (5)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Job Number: 41381

Part Number: PB674300151

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST513

JS 08/10/06 XS

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/08 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/12-06

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

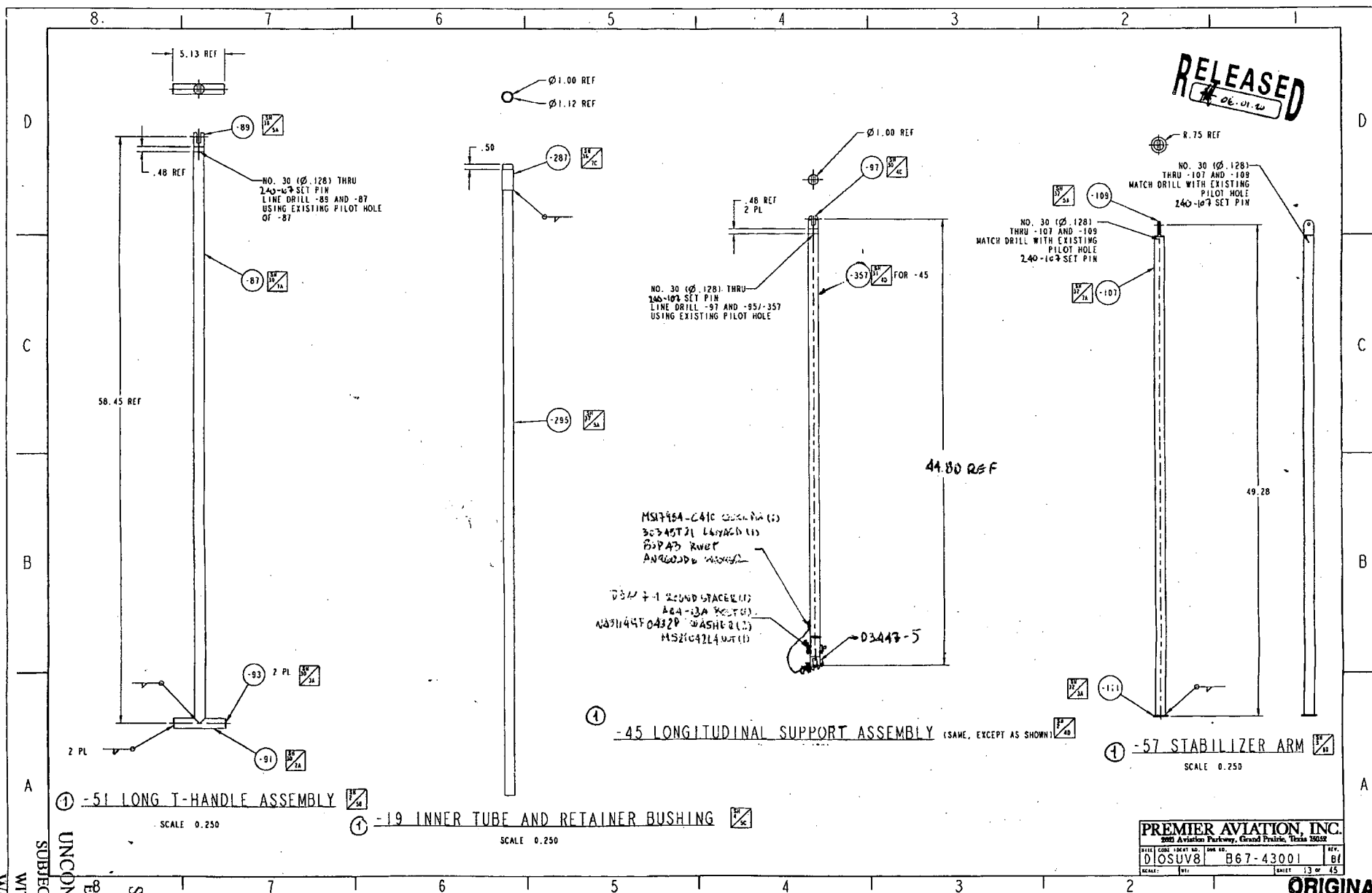
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

RELEASED
06-01-60



PREMIER AVIATION, INC.
2000 Aviation Parkway, Grand Prairie, Texas 75050

| | | | |
|---------|------|-----------|----------|
| DATE | CODE | REV. NO. | REV. |
| 0105UV8 | | 867-43001 | 81 |
| SCALE | 1:1 | SHEET | 13 OF 45 |

ORIGINAL

NO. 41381
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY